

Date: Friday, 9/15/2006 12:00:42 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTSIDE WASHER
Job Number : 28620	
Estimate Number : 11154	
P.O. Number : N/A	Part Number : D32335
This Issue : 9/15/2006 S.O. No. : N/A	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : N/A	Material : N/A
Type : MACHINED PARTS	Due Date : 9/30/2006
Written By : <i>[Signature]</i>	Qty: 26 Um: 20 Each
Checked & Approved By : <i>[Signature]</i> 06/09/15	
Comment : Est. A 05.03.14 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR1875W250	COLD DRAWN ROUND TUBE
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Comment: Qty.: 0.1860 f(s)/Unit Total : 3.7191 f(s)
1020-1025 Round Tube
Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020
SRA or AMS 5075 or AMS 5077
(M1020TR1.875W.250)
Identify for D3233-5
Batch: *M102210*

[Signature] 06/09/27

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONV.LATHE
Turn as per Dwg D3233

[Signature] 06/09/27 26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/09/28 26

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1- Mill as per dwg D3233
2-Deburr

[Signature] 06/09/28 26

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

[Signature] 06.09.29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/10/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 12:00:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 28620

Part Number: D32335

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WAT*

PB 06/10/02

26

7.0

QC21

FINAL INSPECTION/W/O RELEASE



28

Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

Job Completion



W 06-10-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

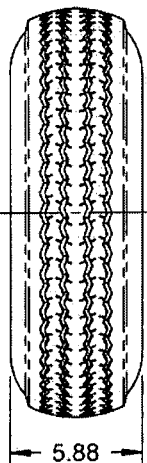
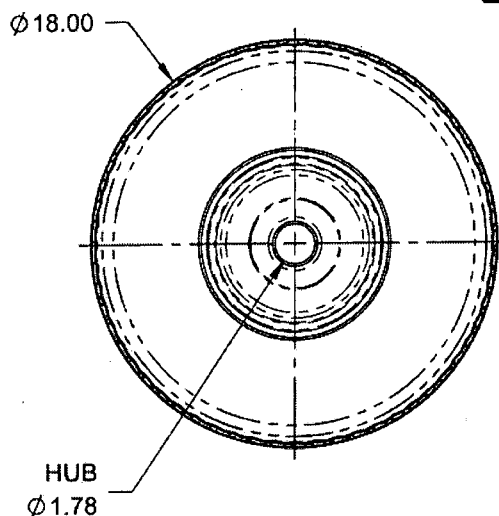
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



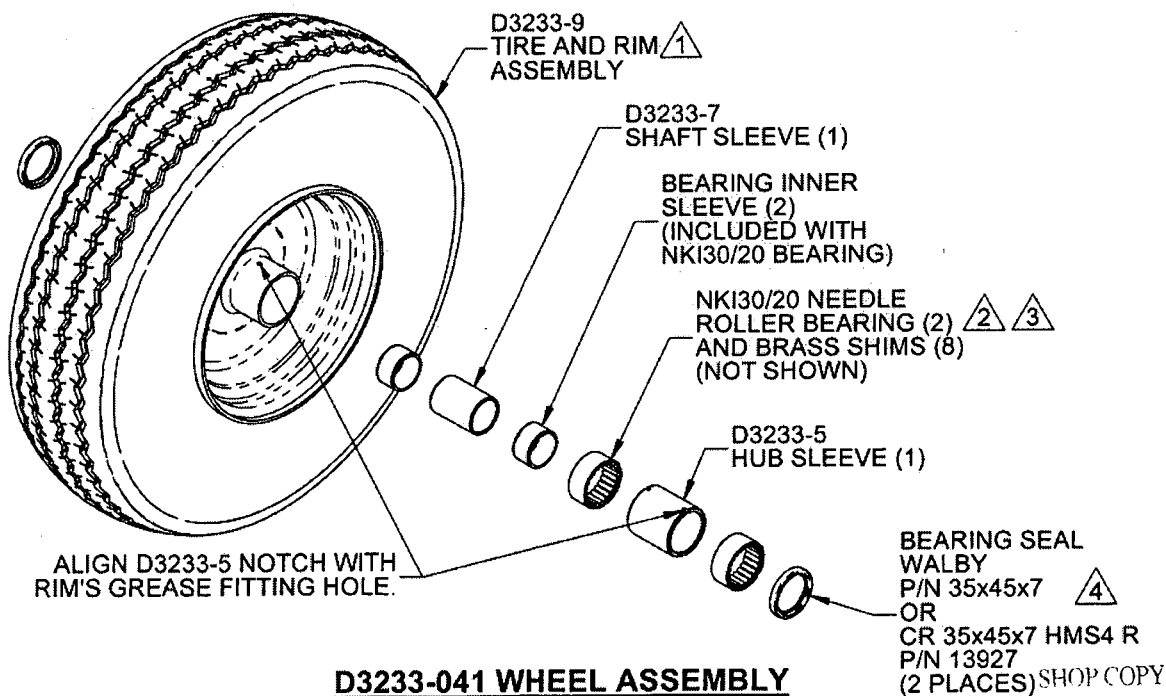
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CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

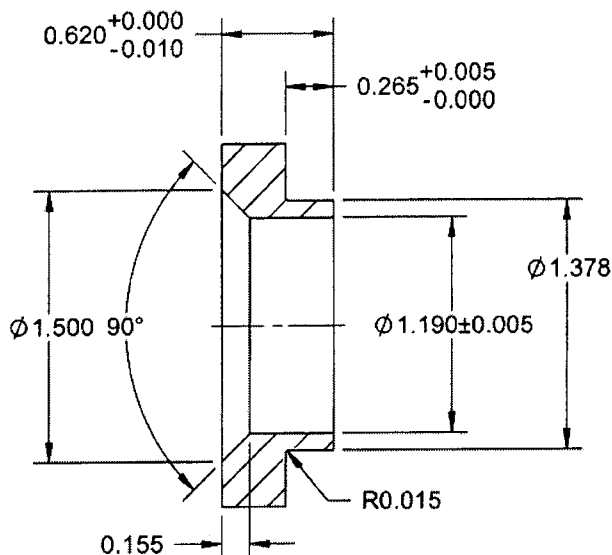
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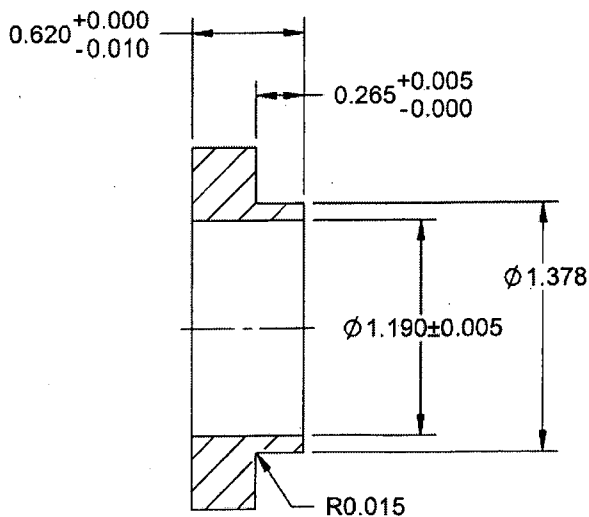
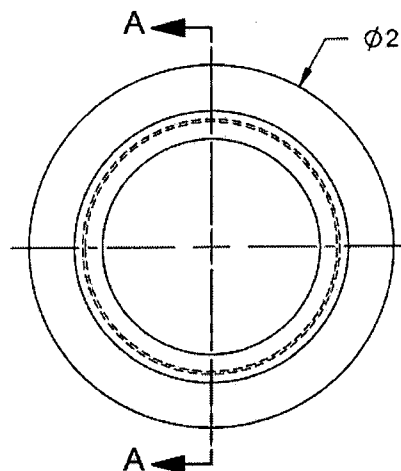


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



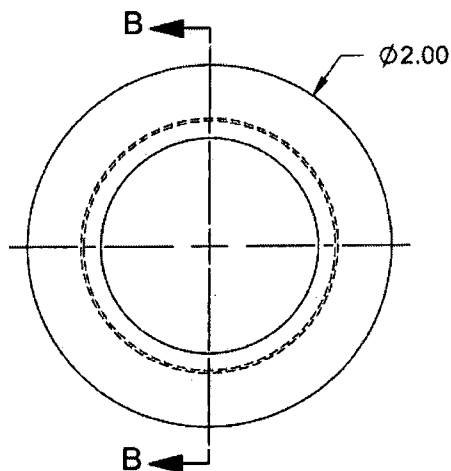
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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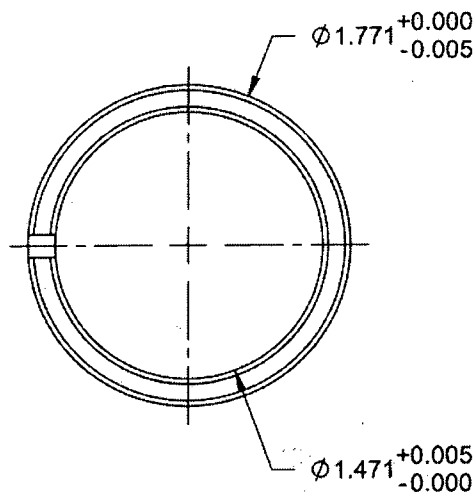
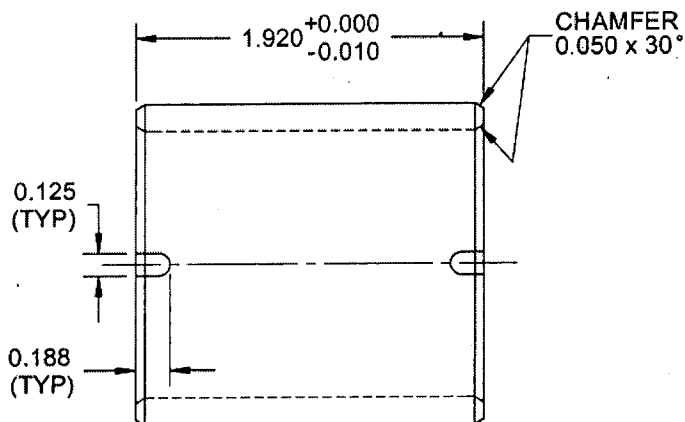
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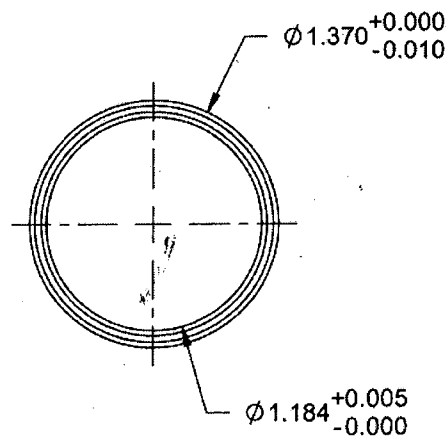
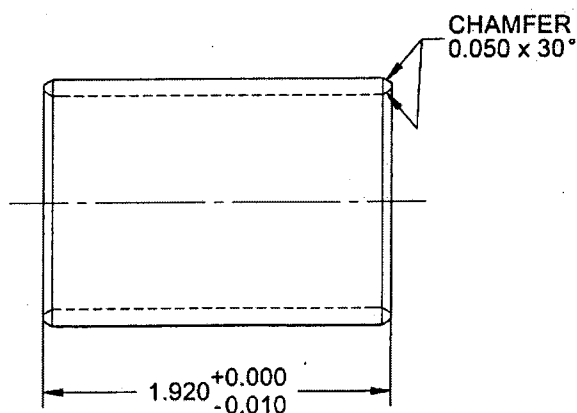


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DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513.100 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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